

Green

Dart Aerospace Ltd.

Date: Tuesday, 24/02/2009 10:14:14 AM
 User: Melanie Fauteux

Process Sheet

TULMAR

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER PLATE
 Job Number : 46056
 Estimate Number : 13394
 P.O. Number : Part Number : PB6743001181
 This Issue : 24/02/2009 S.O. No. : Drawing Number : B6743001 PAGE29
 Prsht Rev. : NC Project Number : N/A
 First Issue : 11 Type : SMALL /MED FAB Drawing Revision : ~~B1~~ C PRELIM 09.02.24
 Previous Run : 44994 Material :
 Written By : Due Date : 03/03/2009 Qty: 12 Um: Each
 Checked & Approved By : MF 09-02-24
 Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

Additional Product

PRELIMINARY ISSUE

Job Number:



09.02.24

Seq. #: Machine Or Operation: Description :

1.0

M2024T3S032

2024-T3 .032 sheet



Comment: Qty.: 1.1101 sf(s)/Unit Total: 13.3207 sf(s)

2024-T3 Sheet 0.032"

patch: 10778

ml 09 02 25 (12)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001

Dwg Rev: Prelim

Prog Rev: Prelim

****grain direction along 7.25" ****

2-Debur if necessary

ml 09 02 25 (12)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 02 25

(12)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09.02.27 (12) ENGINEERING APPROVAL

09.02.27

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg B67-43001

SB 09/03/02 (12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE

Job Number: 46056

Part Number: PB6743001181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

09.03.07

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

APPROVAL

09/03/07

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

1:15

OVEN TEMPERATURE:

320°

FINISH TIME:

1:45

FL 09/03/03

(12)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 09-03-03 12

10.0

PACKAGING 1

PACKAGING RESOURCE #1



710.8192.

09/03/03

(12)



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker on the bottom side of the part

11.0

QC5

INSPECT WORK TO CURRENT STEP



09/03/07



Comment: INSPECT WORK TO CURRENT STEP

12.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

710.8196

09/03/03

(12)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

09/03/06 (12)

Date: Tuesday, 24/02/2009 10:14:15 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE

Job Number: 46056

Part Number: PB6743001181

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

MF 09/03/24

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57437*

09/03/24 8 (74)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/09/16

Job Completion:



MF 09-03-25

POSITIVE RECALL

EFFECTIVE *09.02.24*

RELEASED

AUTH *L*

DATE *09.03.24*

09.03.30



*Per GCN #10-56A
10.06.14*

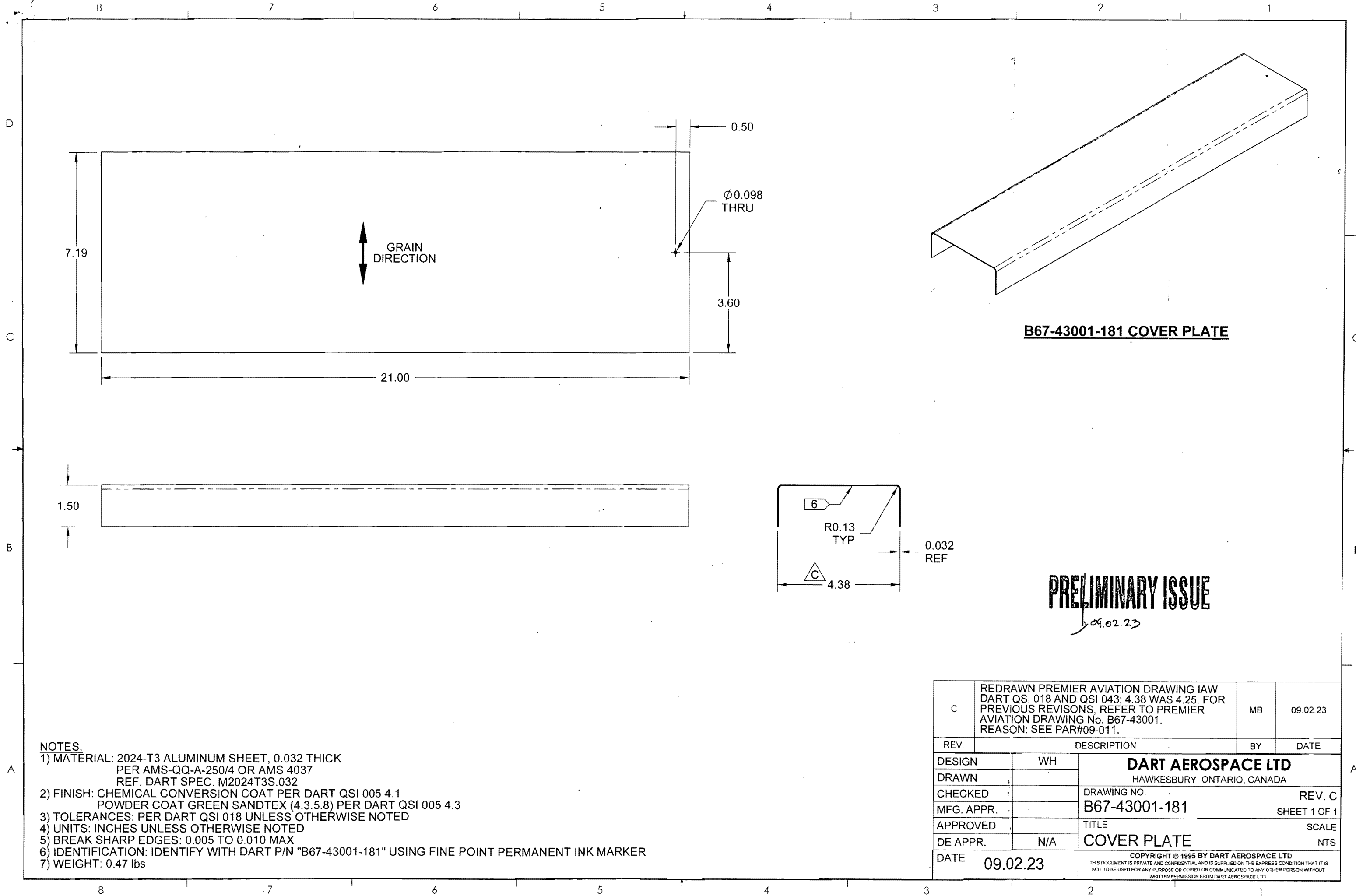
010724

☒ **First Article** ☐ **Prototype**

$$\max 0.099 - 0.101$$

4

by	Appr
	



FAXED
11-5-08**CLIFTON**
Adhesive, Inc
Industrial Adhesives & Coatings

Date: 11/4/08

Shipper #: 11489

Certificate of Compliance

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,
lot number (s) 08-294 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/20/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/20/09

This letter certifies that 5 x quart cans of CATUR Accelerator,
Lot number 08-305 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/31/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/31/09

Sincerely,

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Burgess Place • Wayne, NJ 07470 USA
Phone: 973-694-0845 • Fax: 973-694-5678
www.cliftonadhesive.com

7122/24. (S)



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 9, 2008

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Fax From: Sharon James

**EDMONTON
HEAD OFFICE**

12122 - 68 Street
Edmonton, AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 14881-00 for Oxford 7 Black

The goods shipped on P/O 14881-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 08/06/08

Lot Number: 35896

Sincerely,
J. Ennis Fabrics Ltd.

S James

Sharon James
Product Development

TORONTO

6300 Kenway Drive
Mississauga, ON L5T 2N3
Canada

CALGARY

2nd Floor, 337 - 17 Avenue SW
Calgary, AB T2S 0A5
Canada

VANCOUVER

13911 Bridgeport Road
Richmond, BC V6V 1J6
Canada

MONTREAL

8280 boulevard du Golf
Anjou, QC H1J 3A1
Canada

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

NO. 355 P. 2

J ENNIS FABRICS LTD

OCT 9 2008 1:09PM

41/5815 #55L

82

frmGovernment

Page 1 of 2



American & Efird Inc.
Post Office Box - 507
Mount Holly, NC -28120

Test Report

Date : 1/26/2009

QLL No. 844

Mfg. Date : 1/12/2009

Quantity: 16.9

Lot Id : 566518

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : VT295E TPII CLA F BT92N4

Customer Order Number : 15245-00

Plys (Visual) : 4

Customer : Tulmar Safety

Twist Direction : Z

Shipped To : Tulmar Safety

A&E Color: 63002 Black
AA

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.3	14.8	15.3	15.3			
Strength #2 (Pound)	15	14.9	15	15.1	15.1			
Average Strength (Pound)						15.1	11.8	
Elongation #1 (Percent)	21.9	22.4	21.3	22.3	22.1			
Elongation #2 (Percent)	21.8	21.5	22.3	21.9	21.7			
Average Elongation (Percent)						21.9		26
Twist S #1 (Turns per inch)	12.3							
Twist S #2 (Turns per inch)	12.3							
Average Twist S (Turns per inch) Initial Twist						12.3		
Twist Z #1 (Turns per inch)	8.2							
Twist Z #2 (Turns per inch)	8.2							
Average Twist Z (Turns per inch) Final Twist						8.2	5.5	
Yield #1 (Yards/Pound)	4077.2							
Yield #2 (Yards/Pound)	4126.1							
Average Yield (Yards/Pound)						4101.6	3600	5200

Shade Evaluation : GOOD
 Laundering : GOOD
 Perspiration : GOOD

frmGovernment

Page 2 of 2

Wet Dry Cleaning :	<u>GOOD</u>
Light Test :	<u>GOOD</u>

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed : *Jeff D. Munday*
Testing Director

Note This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in it's entirety.

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

Date : 07/15/2005

FOURNISSEUR
VENDOR

E.F. WALTER INC.
5000 HICKMORE
ST. LAURENT, PQ
H4T 1K6

Commande / Order # 10280

Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Piece # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72' (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72' (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé
Signed

[Signature] July 15, 2005

Re #1637-001/01 (C)

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

Date : 09/09/2008

FOURNISSEUR
VENDOR

E.F. WALTER INC.
180 BARTOR ROAD
TORONTO, ONTARIO
M9M 2W6

Commande / Order # 14649-00

Notre / Our Reference # 55968

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

Signé
Signed

09/09/2008

Tsc # 1637-001 / 02

PACKING SLIP

TULMAR

COPY

Packing Slip No.

31826

Ship Date

6-Mar-09

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : XOTULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order number	Sales order date	Account number	Account manager
22836	17-Feb-09	CDART100	Barney Bangs
PO number	Ship Via	PPD/COL	
PO00008196	Pick-Up		
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-103

12

EA

12

Dart Blade Fold Kit - Pad #4/

Drawing No: (Ref B67-43001-181 Rev B1)

DWG Rev: A

Lot No: BATCH0000000005 Qty: 12

Shipper

Date: MAR 06 2009

Certificate of Conformance☐ Not Applicable

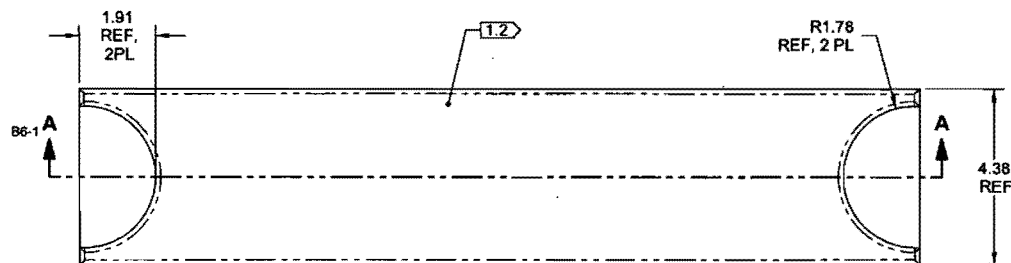
I hereby certify that the items listed hereon have been inspected/tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file and can be made available upon request. If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

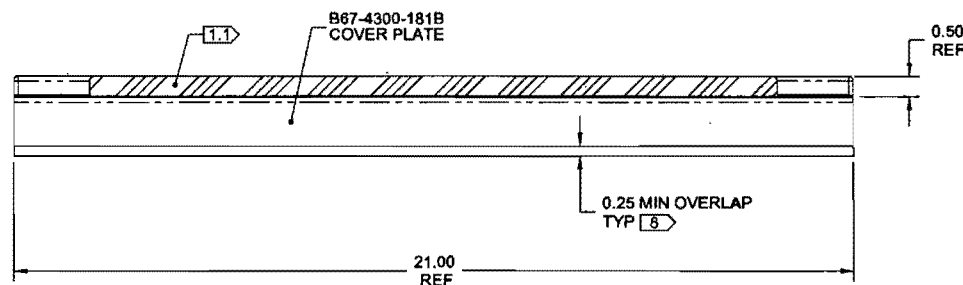
Lorraine LaLiberte

Date: 03/06/2009

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-181	COVER PLATE ASSEMBLY
2	1	B67-43001-181B	COVER PLATE
3	A/R	1673-001	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3



B67-43001-181 COVER PLATE ASSEMBLY



SECTION A-A D8-1

NOTES:

1) MATERIAL:

1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK REF. TULMAR P/N 1637-001

1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK REF. TULMAR P/N 1495

1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009

2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.

3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

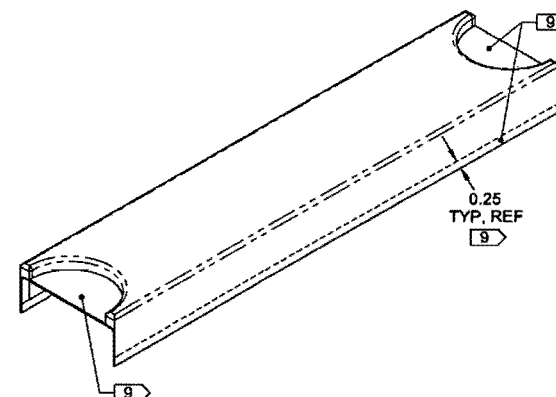
5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.78 lbs REF

8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE

9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE



RELEASED
2010-09-16
MP

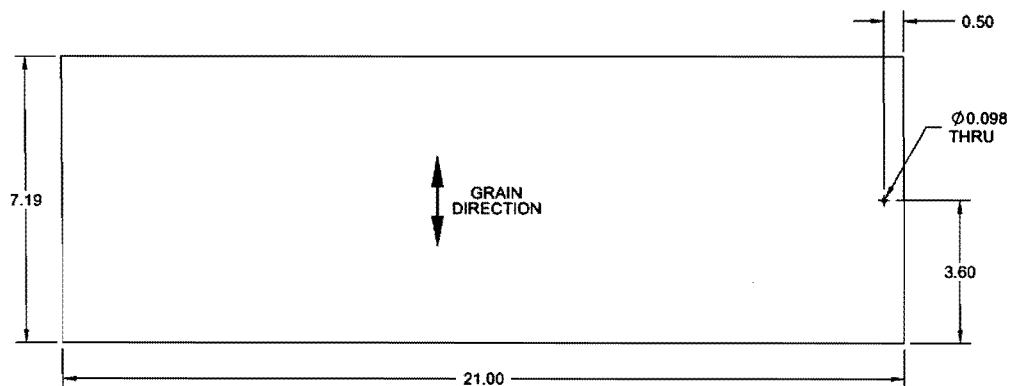
46056

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC; 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 29 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
	REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		B67-43001-181	SHEET 1 OF	
APPROVED	AM	TITLE	SCALE	
DE APPR.	N/A	COVER PLATE	NT	
DATE	10.04.27	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

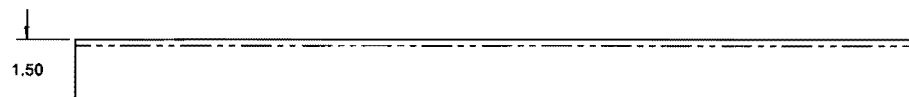
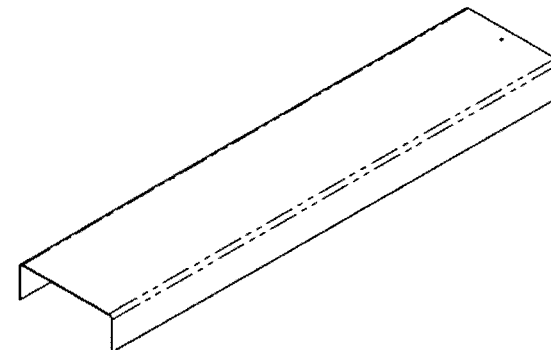
TABLE 1

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)

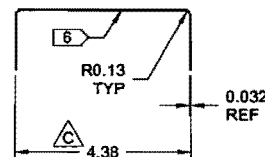
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40



B67-43001-181F FLAT PATTERN



B67-43001-181B BENDING DETAIL
(MAKE FROM B67-43001-181F)



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-181B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.48 lbs

RELEASED
2010-09-16

46056

DESIGN	R/V	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-181	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER PLATE	NTS
DATE	10.04.27	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	